Work Order ID 107239 Page 1 September-23-13 11:36:20 AM Item ID: D3913-041 Accept *N900040100* **Revision ID:** Long Basket Base Assemby, 350 Item Name: Start Qty: 1.00 **Start Date:** 10/02/13 **Cust Item ID: Reg'd Qty:** 1.00 Required Date: 10/07/13 **Customer:** Reference: Run Start Process Plan: Date: 3-09-27 Tooling: Approvals: Stop Date: SPC (Y/N): Date: Reject Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Insp. Description Work Center ID **Run Hours** Code Oty Qty Number Stamp **Draw Nbr Revision Nbr** D3913 D4020 Α Weld per dwg A/R S.S. rod Batch: 1248/6 100 0.00 Large Fab *100* 0.00 Large Fab Large Fab 1- assemble ribs, weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-i base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

*11**0***

Memo

0.00

Quality Control

13,10.16

								DQA:	Date	; <u> </u>		
NCR: Yes	s / No				WORK ORDER NON-C	ON	FORN	MANCE / UPI	DATE	QA Closed:	Date	:
Work Order:					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
Part No.	•				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- ∔	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	1	Initial Action nief Eng Description			Sign & Date	Verification	QC Inspector
occ/Data quip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
			·		······································	AULT	CATE	GORY				
Landing	g Gear Bending Centre Not Concentric to O/S Cracks			o/s	General Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			Ovalized Over/Under Part Incorre	-	Pressure/Forced Temperature/Cure Weld
	Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			Burrs Contamination Countersink Cut Too Short		Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Part Lost/Mi Part Moved Positioned V Power Loss/	Vrong	Wrong Stock Pulled Other	
	Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube		Drill Holes Drawing Finish		Offset Out of Calibration Out of Sequence Outside Dimensions							

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 2

September-23-13 11:36:20 AM

Item ID: D3913-041 Accept *N900040100* Setup Start **Revision ID:** Long Basket Base Assemby, 350 Item Name: Start Qty: 1.00 **Start Date:** 10/02/13 **Cust Item ID:** Required Date: 10/07/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Tooling: Approvals: Date: Date: Stop Date: _____ SPC (Y/N): Date: Reject Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Operation Insp. Number Stamp **Work Center ID** Code Qty Description **Run Hours** Qty QC5- Inspect part completeness to step on W/O 0.00 DAS 120 *120* 13-10-11 OC 0.00 Memo Quality Control 125 Pressure Wash per QSI005 4.3 0.00 76-10-17 *125* HandFinish 0.00 Memo Hand Finishing

NCR:	Yes	1	No
NCK.	162	/	1110

DQA: _____ Date: ____ '

NCR: Ye	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:												
Work Orde	ř:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N					Rework Scrap		N	Skid-tube Aachining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	0				Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance		Initial Action Chief Eng Descrip		cion ription	Sign & Date	Verification	QC Inspector	
oc/Data	Date	зсер	Qty		or won-comormance	Cine	LIIE	Desci	iption	Date	·	Qe mapeetor	
quip/Tooling	1	1											
perator	7												
/laterial		1.				1							
etup	7												
Other				ڬ		1							
rocess													
upplier									•				
raining													
Inapproved													
						FAULT	CATE	GORY					
Landin	g Gear				General				_	_	_	_	
	Bending				Bend	G	rain			Ovalized	L	Pressure/Forced	
	Centre N	Not Conce	ntric to (o/s	BOM/Route	\vdash	ardwa			Over/Under	<u> </u>	Temperature/Cure	
ļ	Cracks				Broken/Damaged		•	on Incomplete		Part Incorre	ct	Weld	
1		/Crimped			Burrs	-		ons incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
[Cuffs	 			Contamination	<u></u>	1ainte	nance		Part Moved			
ļ	Heat Treat Countersink			┽	∐∾	islabe	led	L	Positioned V	· -			
ļ	Inspection Strip in Tube Cut Too Short			Шм	1isread			Power Loss/	Surge	Other			
ļ	Ripples in Bend Drill Holes			\vdash	ffset								
Ĺ	Torque '	Waves in	Extrusio	n L	Drawing	—		Calibration					
	Turning	Sequence	<u></u>	Į.	Finish	Ц٥	ut of S	equence				,	
	Wave/Twist in Tube					Outside Dimensions							

Work Orde September-23-13					Page 1							
Item ID: Revision ID:	D3913-041			Accept	*N900	040	100)*	Setup Sta	11	JS1	*
Item Name:	Long Basket E	Base Assemby, 350							St	ob *	JS2	*
Start Date: Required Date: Reference:	10/02/13 10/07/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							
Approvals:	Process Pla	in:	Date:	Tooling:	D	ate:		. 1		art *\	JR1	*
	QC:		Date:	_ SPC (Y/N):	D	ate:			Si	op */	JR2	*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp er Stan	
130 *130* Powdercoat		White Gloss(Ref:4.3.5.2)) per QSI005 4.3-Steel	0.00				1	0	13-10-	17.	DAS 34
Powder Coating		IST COAT: START TIM OVEN TEM FINISH TIM ********** 2ND COAT START TIM OVEN TEM	ME: <u>/. 4/5</u> MPERATURE 400 ME 1/5. ************ 2nd coat if ne	of hinge (3) prior to powder	****							9-89

140

QC3- Inspect Part Finish

0.00

140

Memo

Quality Control

0.00

Lx & Mysholo

NCR: Ye	es / No				WORK ORDER NON-C	CONF	ORN	/IANCE / UPI	DATE	•	···	
										QA Closed:	Dat	e:
Work Order	:				DISPOSITION	,				PARTMENT	-	
Part No	o				Rework Scrap	 	ľ	Skid-tube Machining	Crosstube Small Fab	⊣	Water Jet d. Eng. Coor.	Engineering Quality
NCR No	0				Use-as-is Work Order Update] '		oforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data equip/Tooling												
Operator												
Material	· .					1						
Setup												
Other												
rocess	1											
Supplier	7											
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Landin	g Gear				General					_	_	
	Bending				Bend	Gı	rain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	На	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	ln:	specti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	In	struct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	М	lainte	nance		Part Moved	_	
•	Heat Trea	it			Countersink	М	islabe	led		Positioned V	Vrong _	<u></u>
Γ	Inspectio	n Strip in	Tube		Cut Too Short	М	isread	1		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	01	ffset		_			
	Torque W	/aves in l	Extrusion	,	Drawing	По	ut of C	Calibration				
	Turning S	equence			Finish	По	ut of S	equence				
	Wave/Twist in Tube			}		Outside Dimensions						

DQA:

Date:

Work Order ID 107239 Page 4 September-23-13 11:36:20 AM Item ID: D3913-041 Accept Setup Start *N900040100* **Revision ID:** Item Name: Long Basket Base Assemby, 350 **Start Date:** 10/02/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 10/07/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date:_____ Tooling: Approvals: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Reject Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. **Work Center ID** Description Code Qty Qty Number Stamp **Run Hours** DAS 150 Assemble as per dwg 0.00 32 *150* HandFinish 0.00 Memo Pick Kit Hand Finishing 160 QC5- Inspect part completeness to step on W/O 0.00 DAS 27 *160* 9.89 0.00 Memo 13.10-18 Quality Control D4030-041 B107248 Identify as per dwg & Stock Location: W \(\) 170 1x & Il 1/10/18 *170*

0.00

Memo

Packaging

Packaging

NCR:	Vac	•	NI.
NUK:	Yes	,	No

DQA:

Date:

NCR: Y	es	/ No				WORK ORDER NON-	COL	VFORM	MANCE / UP	DATE			`•	
											QA Closed:	Date	:	
Vork Orde	ŕ:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	lo.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	-					Use-as-is]	Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	lo.					Work Order Update]	İ	Large Fab	Composite	teSupplier			
Root					Descr	iption of work order update		Initial Action		tion	Sign &		<u> </u>	
Cause		Date	Step	Qty		or Non-conformance		ief Eng		ription	Date	Verification	QC Inspector	
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etup			:											
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rocess	s H													
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napproved														
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Landi	ng (Gear				General	_			_	_	_	_	
		Bending				Bend		Grain			Ovalized	L	Pressure/Forced	
		Centre No	t Concer	ntric to (o/s L	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		inspect	on Incomplete		Part Incorre	ct _	Weld	
		Crushed/0	Crimped		L	Burrs	L	Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	enance	L	Part Moved			
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	-	
		Inspection	n Strip in	Tube		Cut Too Short	L	Misread	1		Power Loss/	Surge	Other	
		Ripples in	Bend			Drill Holes		Offset					· · · · · · · · · · · · · · · · · · ·	
		Torque W	aves in E	xtrusion	າ [Drawing		Out of 0	Calibration					
		Turning S	equence			Finish		Out of S	Sequence					
	Wave/Twist in Tube		Folio		Outside Dimensions									

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Work Ord <i>September-23-1.</i>			*107239*									Page 5			
Item ID: Revision ID: Item Name:	D3913-0	041 sket Base Assemby, 350		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*			
Start Date: Required Date: Reference:	10/02/13	3 Start Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					I	. 7/			
Approvals:	Process Plan:QC:		Date:	Tooling: SPC (Y/N):	Date:Date:			Run 		Start Stop	*N *N	R1* R2*			
Sequence ID/ Work Center II 180 *180* QC Quality Control	D	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept	Rej Qty	m 13	Reject Number 3/10/2 F	Insp. Stamp			

NCR:	Yes	1	No
NUK:	162	/	INO

DQA:

Date:

NCR: Ye	es / No				WORK ORDER NON-C	CONF	ORN	//ANCE / UP	DATE				
,										QA Closed:	Dat	te:	
Work Order					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering	
Part No	o				Scrap		ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is] 7	Thermoforming Finishin			Rec/Sto	re/Packaging		
NCR No	0				Work Order Update	J	Large Fab Compo			osite Supplier Supplier			
Root				Descri	ption of work order update	Init	tial	Ac	ction	Sign &			•
Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Desc	cription	Date	Verification	n QC Inspector	_
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Landin	g Gear				General	AULI	CATE	JONT				·-·	-
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<u> </u>	Centre No	ot Conce	ntric to C	_{0/5}	BOM/Route	\vdash	ardwa	re	 	Over/Under	tolerance	Temperature/Cure	
<u> </u>	Cracks			" <u> </u>	Broken/Damaged	\longrightarrow		on Incomplete		Part Incorre	ŀ	Weld	
<u> </u>	Crushed/	Crimped			Burrs	$\overline{}$		ions Incomplete/	/Unclear	Part Lost/M	1	Wrong Stock Pulled	
·	Cuffs				Contamination			nance		Part Moved			
. [Heat Trea	at			Countersink	Пм	lislabe	led	<u> </u>	Positioned V			
ľ	Inspection		Tube		Cut Too Short	\vdash	lisread			Power Loss/		Other	
	Ripples in	•			Drill Holes	По	ffset			_ ·	- L		٠
	Torque W		xtrusion	,	Drawing	\Box	ut of C	Calibration			-,		•
<u> </u>	Turning S	equence			Finish	По	ut of S	Sequence					•
Ī	Wave/Tw	ist in Tul	эе		Folio	По	utside	Dimensions					•

Work Order ID:

107239

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Start Date: 10/02/13

Required Date: 10/07/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

verified by:EC

IPP Rev:B chg qty's DD 10.04.12 IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ſ	D3913-1 Rib		Manufactured	No			100	Each	9.0000	1	1		3-/6	.9
					Location		Loc Qty	<u>L</u>	oc Code	B	1001	160-		-11
					WA		1					•		(1
					979	979	1							
					WA005		8							
						0460	7							
	/				886	537	1						2	
V	D3913-3 Rib		Manufactured	No			100	Each	10.0000	1	1	G	12	·/c
					Location		Loc Oty	<u>L</u>	oc Code	'3	B100	443-		-77
					WA004		1					•		
					100	0442	1							
					WA005		9							
					100	0443	7							
						160	1						_	
1	1				84	651	1						7	
J	D3913-7 Rib		Manufactured	No			100	Each	12.0000	2	2	G	13	10.
					Location		Loc Oty	<u>1</u>	oc Code		399	-	_>	- <u>(v</u>)
					WA004		11				B 101	o 23 ~		
					10	0483	4							
						1023	4							
						781	3							
					WA006		l				man .			
					10	0482	1				-			

			DQA:	Date:	1	•
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE				

											QA Closed:	Date	2:
Work Orde	er:			• •		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	- ۱۰۰					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Ī				Descri	ption of work order update	Ti	nitial	A	ction	Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		•										·	
1,1				1 1		F	AUL	T CATE	GORY			1	
Landi	ng (Gear				General							
		Bending Centre No Cracks Crushed/			o/s	Bend BOM/Route Broken/Damaged Burrs		4 `	ire ion Incomplete ions Incomplete	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs				Contamination	\vdash	Mainte	•		Part Moved		
		Heat Trea	at		<u> </u>	Countersink		Mislabe			Positioned V	Vrong	
	Г	Inspectio		Tube	<u> </u>	Cut Too Short		Misread			Power Loss/		Other
	-	Ripples in	,			Drill Holes		Offset		<u> </u>	-	· L	
	Г	Torque W	Vaves in E	Extrusion	,	Drawing		Out of 0	Calibration			, , , , , , , , , , , , , , , , , , ,	
		Turning S	Sequence			Finish		Out of 9	Sequence				
		Wave/Tu	vist in Tul	he		Folio		Outside	Dimensions				

Work Order ID: Parent Item: Parent Item Name:	107239 D3913-041 Long Basket Base Assemby, 350						Date: 10/02/13	Required Date: 10/07/13 Required Qty: 1.00
D3913-9	Manufactured	No		100	Each	4.0000	1	1/2/12:10:9
Hinge Rib			Location	Loc Qty		Loc Code	事/	00305
			WA004	3				
			102353	3				_
			WA005	1				_
/			70138	1				- /
D3916-5 Light Rib	Manufactured	No		100	Each	18.0000	3	3 (pl,3.10.9)
			Location	Loc Qty		Loc Code	3	B103750->-3
			WA004	3				<u></u>
			104316	1				
			94698	2				<u> </u>
			WA005	15				_
			103589	6				_
			103590	4				
			77142	1				_
1			82933	4				-
D3916-041 Rib Assembly	Manufactured	No		100	Each	10.0000	2	2 (DC/3·10·9
·			<u>Location</u>	Loc Oty		Loc Code	•	B102430-
			WA004	8				_
			100359	8				
			WA005	2				·· _
			81444	2				- .

									DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-	CONFO	RMANCE / UF	PDATE	QA Closed:	Date	,
									-	. 117.	•
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo.				Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	10				Work Order Update	」	Large Fab	Composite	j	Supplier	
Root		I		Descr	iption of work order update	Initia	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator				•							
Material											
Setup											
Other									1		
Process											
Supplier		ļ									
Training		1									
Unapproved		<u> </u>							<u> </u>	<u> </u>	
						AULT CA	TEGORY				
Landir	ng Gear			_	General				7	_	_
	Bending				Bend	Grai			Ovalized	ļ	Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	_	ware		Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	⊢ ⊢ `	ection Incomplete		Part Incorre	<u> </u>	Weld
	Crushed/	Crimped		L	Burrs		uctions Incomplete	e/Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination	\blacksquare	ntenance		Part Moved		
	Heat Trea			<u> </u>	Countersink	$\boldsymbol{\vdash}$	abeled		Positioned \		7
	Inspectio		Tube	_	Cut Too Short	Misr	ead		Power Loss/	/Surge	Other
	Ripples in				Drill Holes	Offse					
:	Torque V	Vaves in 1	Extrusio	n L	Drawing	—	of Calibration				
	Turning Sequence				Finish Out of Sequence						•

Outside Dimensions

Wave/Twist in Tube

Folio

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Picklist Print September-23-13 11:36:19 AM

Work Order ID:	107239								
Parent Item:	D3913-041							Date: 10/02/13	Required Date: 10/07/13
Parent Item Name:	Long Basket Base A	ssemby, 350					Star	t Qty: 1.00	Required Qty: 1.00
D4017-7 Rib		Manufactured	No		100	Each	9.0000	3	3 Cp(13.10.9
				Location	Loc Qty		Loc Code	\mathfrak{F}	106155-2
				WA004	5				
				94821	5				
				WA005	. 4				
				69730	1				
				82969	I				<u> </u>
				85435	1			****	·
				88392	1				_ / /
D4017-9 Rib		Manufactured	No		100	Each	17.0000	2	2 (g(13-10
				Location	Loc Qty		Loc Code	310	7114 - (a)
				WA004	10				_ `
				107114	10				
				WA005	7				<u></u>
				100536	4				
				70341	2				
				81445	1				
D4034-041 Aft Upper Rib Assembly	٧	Manufactured	No		100	Each	7.0000	1	B10495/
				<u>Location</u>	Loc Qty		Loc Code		B10495/-
				WA004	6				-
				103357	2				
				104214	4			-	
•				WA005	1				
				84048	1				

											DQA:	Date	e:
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORI\	AANCE / UPD	ATE			
											QA Closed:	Date	e:
Work Orde	r.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N	lo.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	₹	``											
							AUI	LT CATE	GORY				
Landi		iear Bending Centre No Cracks Crushed/			o/s	General Bend BOM/Route Broken/Damaged Burrs		- '	re ion Incomplete ions Incomplete/U	nclear	Ovalized Over/Under Part Incorre Part Lost/M	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs Heat Trea	at			Contamination Countersink Cut Too Short		Mainte Mislabe Misread	enance eled		Part Moved Positioned V Power Loss/	Vrong	Other
	—	Ripples ir	•			Drill Holes		Offset			-		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 107239 **Start Date:** 10/02/13 Required Date: 10/07/13 Parent Item: D3913-041 Required Qty: 1.00 Start Qty: 1.00 Parent Item Name: Long Basket Base Assemby, 350 D4034-043 No 100 Each 9.0000 Manufactured Fwd Upper Rib Assembly Location Loc Qty Loc Code WA 103421 WA004 104209 WA005 103355 2 82980 D2581 No 100 Each 103.0000 Manufactured Mounting Bracket Location Loc Qty Loc Code WA004 103 103076 24 103952 17 48 105886 70766 2 81253 82506 83230 3 85452 2 2 87706 99837 2 DAS 2 / 150 D2931 Each 2,122.0000 Manufactured No 32 Bumper 9-89 Loc Code Location Loc Qty GA 124 46064 124 ST021 1998 1998 86435

											DQ	A: ِ [Date:	1
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE				
											QA Close	d: [Date:	
Work Ord	er.					DISPOSITION				AGAINST D	PARTMEN	IT/PROCESS		
	-					Rework]		Skid-tube	Crosstube]	Water Je	-	Engineering
Part I	No.					Scrap	4	1	Machining	Small Fab	-1	rod. Eng. Coo		Quality
NCR I	Nο					Use-as-is Work Order Update	┨		noforming Large Fab	Finishing Composite	Rec/S	tore/Packagin Supplie		Other
I I I I						Work order opdate	١		carge rab	Composite	J	Заррііс	·' L	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty	,	or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verificat	on	QC Inspector
Doc/Data														
Equip/Tooling	Ш													
Operator														
Material								:			İ	ŀ		
Setup			ŀ											
Other					Ì									
Process					!									
Supplier							İ					İ		
Training		!			1									,
Unapproved														
						<u> </u>	AUI	T CATE	GORY					
Land	ing (Gear				General	_	-		_	_		_	•
		Bending			L_	Bend	L	Grain		_	Ovalized		L	Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Und	er tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incor	rect	L	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/	Missing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat ...

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	Vork Order ID: arent Item:	107239 D3913-041						Start	Date: 10/02/13	Required Date: 10/07/13
P	arent Item Name:	Long Basket Base Assemby, 3	50					Start	Qty: 1.00	Required Qty: 1.00
	3913-15 Vide Handle Plate	Manufa	ctured	No		100	Each	9.0000	1	1 Pd 13/0.9
					Location	Loc Qty		Loc Code	ź	3105883->
					WA004	9				B977/9-
					104675	4				
					97719	5				- 2
	4016-1 Iinge Half, Base	Manufa	ctured	No		100	Each	68.0000	3	3 Cpc 13:6.9
					Location	Loc Qty		Loc Code		3103414-
					WA004	68				
					103414	28				_
					104200	20				_
					106646	20				- - a
	04021-1 Iandle Plate	Manufa	ctured	No		100	Each	55.0000	3	3 (pl.13.10.9 B105883-
					Location	Loc Qty		Loc Code		R105883-
					WA004	55				
					100366	8				
					100649	4			-	_
					103509	25				_
					105883	15				-
					94596	3				_ / }
	04021-5 Blanking Plate	Manufa	actured	No		100	Each	34.0000	2	2 (6/3-1
					Location	Loc Qty		Loc Code		RIDOSTA
					ST084	34				DAS
		AL 2			103399	27			·	10 3357 DAS 32 989
					103829	6				9-89
					85065	1				
										13/11/12

							DQA:	Date:	· · · · · · · · · · · · · · · · · · ·
NCR: Ye	es / No			WORK ORDER NON-	CONFOR	MANCE / UPDATE	QA Closed	Date:	• • • • • • • • • • • • • • • • • • • •
Work Order Part No NCR No	D	\		DISPOSITION Rework Scrap Use-as-is Work Order Update	-1 1	AGAINST Skid-tube Crosstube Machining Small Fab moforming Finishing Large Fab Composite	Pro Rec/Sto	VPROCESS Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other		Step	Qty	or non-comormane		Description			

Landing	g Gear	General		<u>.</u>	 _	_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
Γ	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong 3	_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration	y	
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio	Г	Outside Dimensions		

FAULT CATEGORY

Supplier Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: Parent Item:	107239 D3913-041					Start I	Date: 10/02/13	Required Date: 10/07/13
Parent Item Name:	Long Basket Base Assemby, 350						Qty: 1.00	Required Qty: 1.00
I	-						-	Λ
D4020-11 End Mesh, Basket	Manufactured	No		100	Each	25.0000	2	2 6612:10:9
End Wesn, Basket			Location	Loc Qty		Loc Code	罗/	07053 (2
			WA004	22				\sim
			107053	22				
			WA007	3				_
			81442	2				_
(84972	1				
D4672-1 Blanking Plate	Manufactured	No		100 .	Each	12.0000	2	2 (p(13.10.9 B100820 ->
			Location	Loc Qty		Loc Code		B100820 ->
			WA004	8				_
			101186	2				
			105887	6				
			WA005	4				
/			88253	4				
M304EX0.75-16F Expanded Metal Flat SS	Purchased	No		100	sf	864.2736	33	33 (p(,3.70.05
			Location	Loc Qty		Loc Code	,	26899-7(33
			WA007	864.2735977				33
			125457	0.00004402				_
			M126052	42.02608				<u> </u>
			M126134	108.417474				<u> </u>
			M126500	73.83				<u> </u>
			M126899	640				<u> </u>

											DQA:	bate:	
NCR: Ye	es	/ No				WORK ORDER NON-C	COI	NFOR	MANCE / UP		QA Closed:	Date:	
						<u> </u>							
Work Order	r:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	-	-				Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part No	ο.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No	o				·····	Work Order Update]		Large Fab	Composite		Supplier	
	_		1		D			in tating I	Λ-	A:	Cian 0	<u> </u>	Γ"
Root		Date	Step	Qty		ption of work order update or Non-conformance	1	Initial iief Eng	1	tion cription	Sign & Date	 Verification	QC Inspector
Cause Doc/Data	\dashv	Date	step	Qty	<u>'</u>	or Non-comormance	1	ilei Liig	Desc	прион	Date	Vermeation	QC IIISPECTOI
Equip/Tooling	ᅦ						1						
Operator	ᅦ		,	ł									
Material					ĺ								
Setup													
Other	_												
Process	4												
Supplier													
Training	\dashv												
Unapproved	_1		l	J	L	F	AUI	T CATE	GORY		<u>i</u>	<u> </u>	1
Landin	ıg G	iear	-			General							
	_	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved
Positioned Wrong

Part Lost/Missing

Power Loss/Surge

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Turning Sequence

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID: Parent Item:	107239 D3913-041					Stant D	eate: 10/02/1	2 г	Required Date	. 10/07/12
		,								
Parent Item Name:	Long Basket Base Assemby, 350					Start	Qty: 1.00		Required Qt	
MS20600-AD4W3 Cherry Rivets	Purchased	No		150	Each	729.0000	2	2	<u></u>	32 1-89
		Loca	tion	Loc Qty		Loc Code				• .
		ST31	1	596						
			122151	4						
			122452	4						
			123525	288				 .		
			124231	300			/24	123/		
		WA0	03	133						
			107939	133					DAS	
1S21042L3	Purchased	No		150	Each	5,946.0000	6	6	< 32	
ut								A-144	∕ 32 9-89	
		Loca	<u>tion</u>	Loc Qty		Loc Code			,	,
		FP00		3					13/15	1180
			122141	3					13/13	1180
		GA		18						
		071	122452	18			-			
		ST31		304			-			
		3131	111668	1				-		
			117885	32						
			119017	55						
			119075	138						
			123265	43						
			M126036	35						-
		ST50	16	1249						
			123900	870						
			124291	379				WEITTY-1814		•
		ST51		4372						
		_ 70	M126275	372					1	
			M126333	4000			MI	633	9	

										DQA:	Date	e: • •
NCR: Y	es / No				WORK ORDER NON-	CONF	ORN	AANCE / UPI	DATE	QA Closed:	Date	۵۰.
7,1-1				······································	DISPOSITION	T		<u></u>	AGAINST DE	***************************************		
Work Orde	r:				DIST OSTITION	_				•	·	
Part N NCR N	••• ; ·				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstul Machining Small Fa Thermoforming Finishin Large Fab Composi			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
WCK IV			·		Work Order opdate	-		carge rab	Composite	j	and bure. [
Root Cause	Date	Step	Qty		iption of work order update or Non-conformance	Init Chief	- 1		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data				ħ	<u> </u>				•			
Equip/Tooling												
Operator		Į										
Material [1										
Setup											<u> </u> 	
Other												
Process			İ									
Supplier												
Training	4											
Unapproved		<u> </u>										<u> </u>
						FAULT	CATE	GORY				
Landir 1	ng Gear			<u></u>	General					J	г	¬
}	Bending			-	Bend		rain		<u> </u>	Ovalized	<u></u>	Pressure/Forced
}		ot Conce	ntric to	^{5/5}	BOM/Route	-	ardwa		-	Over/Under	 -	Temperature/Cure Weld
	Cracks	10			Broken/Damaged	\vdash	•	on Incomplete	Linelana —	Part Incorre		Wrong Stock Pulled
	Cuffs	/Crimped		-	Burrs Contamination			ions Incomplete/I nance	Unclear	Part Lost/M Part Moved	issing [wrong Stock Palled
	Heat Tre	at		-	Countersink	\vdash	islabe	-	<u></u>	Positioned V	Mrong	
	_	อเ on Strip in	Tuho	-	Cut Too Short	\vdash	lisreac		<u> </u>	Power Loss/		Other
	Ripples i		iiube	-	Drill Holes	-	iisi eac ffset	•	<u> </u>	Ti owei ross/	Juige [Cales
		Naves in 1	Extrusio	, · 	Drawing	├ ─┤		Calibration			· · ·	· · · · · · · · · · · · · · · · · · ·
		Sequence		·	Finish			Sequence				,
	J . w		•		1	-						

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: Parent Item: Parent Item Name:	107239 D3913-041 Long Basket Base	Assemby, 350						Pate: 10/02/13 Qty: 1.00		Required Date: 10/07/13 Required Qty: 1.00			
NAS1149F0332P Washer		Purchased	No		150	Each	8,538.0000	12	12 /	DAS 32			
			Lo	ocation_	Loc Qty		Loc Code			9-89			
			G.	4	182								
				122063	182								
			ST	294	158								
				122063	158								
			ST	295	3								
				123352	3								
			st5	510	3195			1,26					
				123900	3195			1239	<u> </u>				
			ST	7510a	5000								
				125646	5000					DAS			
N3-10A		Purchased	No		150	Each	350.0000	6	6	3 2			
olt									s samian e a e	9 -89			
			<u>L</u> c	ocation	Loc Qty		Loc Code						
			ST	T351	14								
				124221	3								
				124858	11								
			Sil	F513	336			10/267	(, S	DAS			
Nacaina	NIA 011 40DN 1020	T	N T-	m125709	336		0.0000	191/20 /		32			
N960JD8	NAS1149DN832.	Purchased	No		150	Each	0.0000	² 12	63/9	32 9-89			
Vasher									-17	13/11/19			

												DQA:	Da	ate:	1
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE		-			
											C	A Closed:	Da	ate:	
Work Ord	er.			·		DISPOSITION				AGAINST DE	EP/	ARTMENT/	PROCESS		
Work Ord	٠,٠,				<u> </u>	Rework	1		Skid-tube	Crosstube	7		Water Jet	:	Engineering
Part I	No.					Scrap	1	ſ	Machining	Small Fab		Prod	d. Eng. Coor.		Quality
	•					Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging	\vdash	Other
NCR	No.					Work Order Update]		Large Fab	Composite			Supplie	-	
Root					Descri	ption of work order update	П	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	\perp	Date	Verification	nc	QC Inspector
Doc/Data	oxdot				 		İ							ŀ	
Equip/Tooling	ᆫ														
Operator															
Material	L										1				
Setup							1								
Other	<u> </u>	,													
Process		,									ļ				
Supplier	$oxed{oxed}$	ļ	Į								ı		•	i	
Training											ı				
Unapproved	<u> </u>	<u> </u>	<u> </u>								\perp				
							AUI	T CATE	GORY						
Landi	ing (1				General		1			_			_	Ī
	_	Bending			_	Bend	\vdash	Grain			-	valized			Pressure/Forced
	<u> </u>	Centre N	ot Concei	ntric to	o/s	BOM/Route	\vdash	Hardwa		_	-	ver/Under			Temperature/Cure
	<u></u>	Cracks			ļ	Broken/Damaged		4	ion Incomplete		-	art Incorrec		\perp	Weld
1		Crushed/	Crimped			Burrs		4	ions Incomplete/U	Jnclear	-	art Lost/Mi	ssing		Wrong Stock Pulled
	\vdash	Cuffs				Contamination		Mainte			-	art Moved			
		Heat Trea	at		L	Countersink		Mislabe	eled	<u></u>	_ P	ositioned W	/rong		-
1	1	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		IР	ower Loss/S	Surge	1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

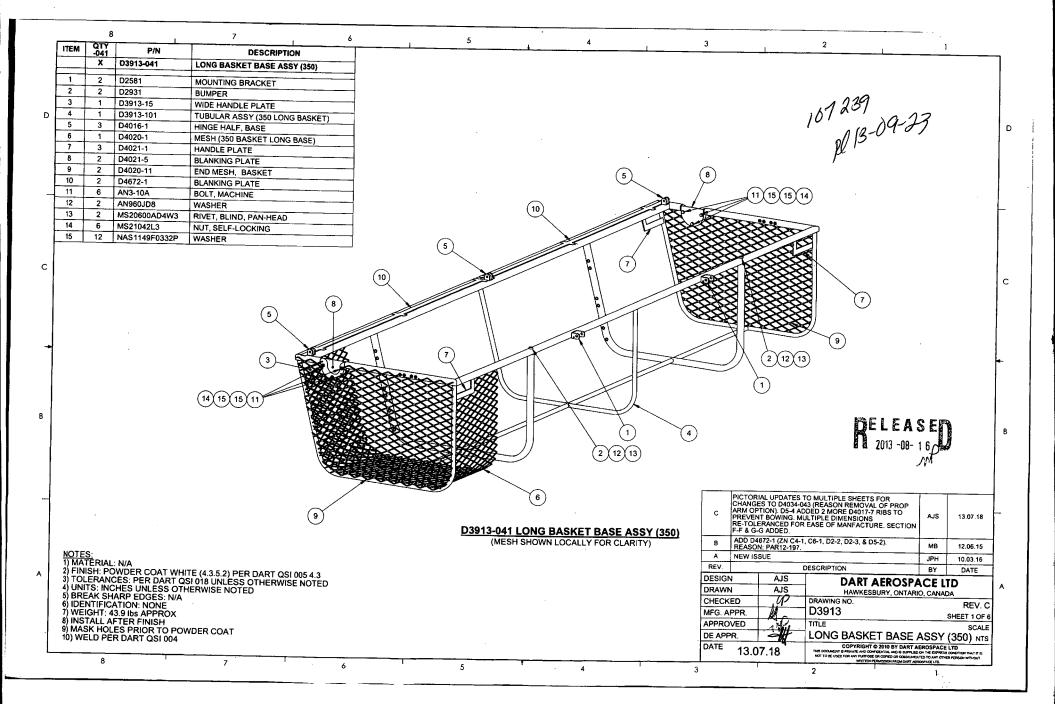
Drill Holes

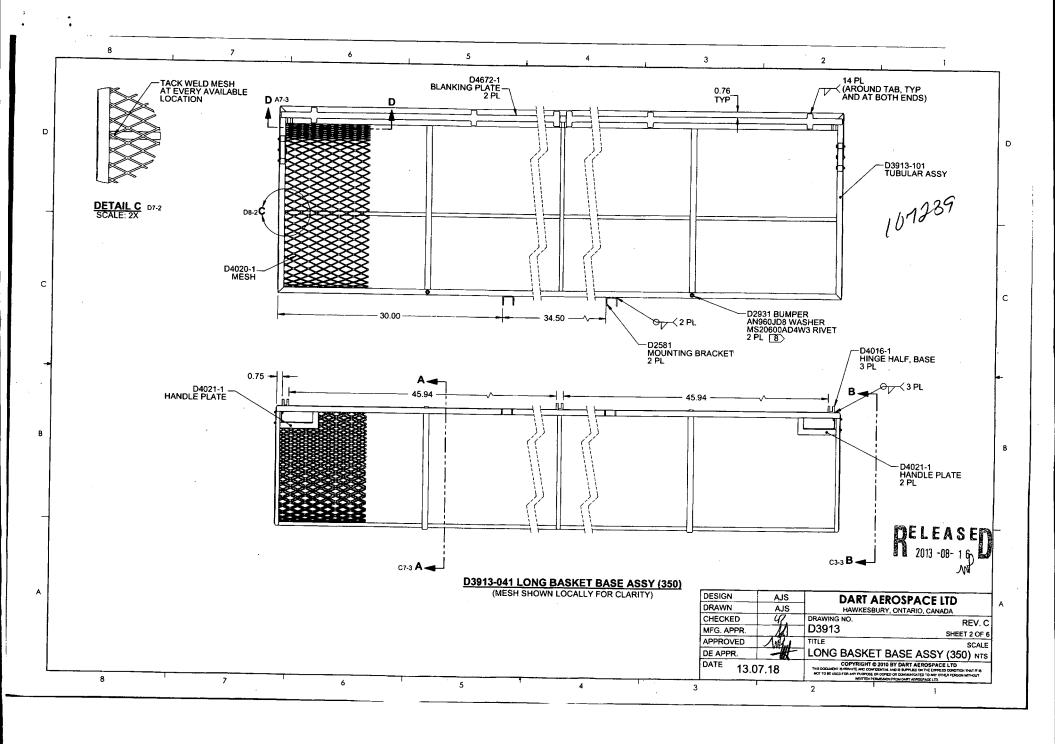
Drawing

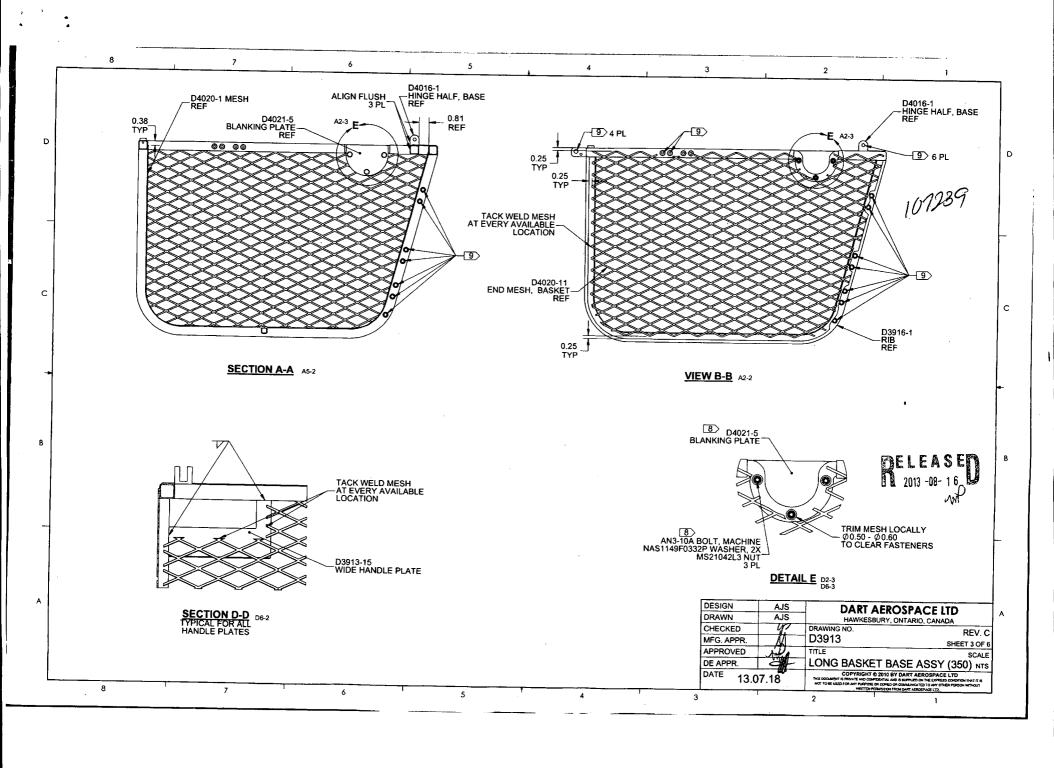
Finish

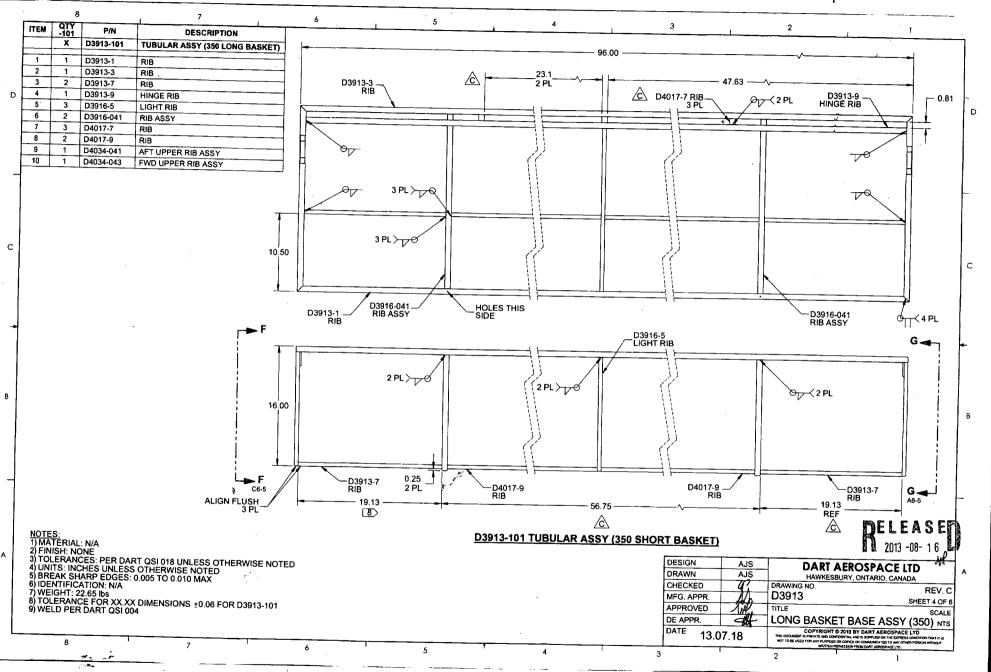
Folio

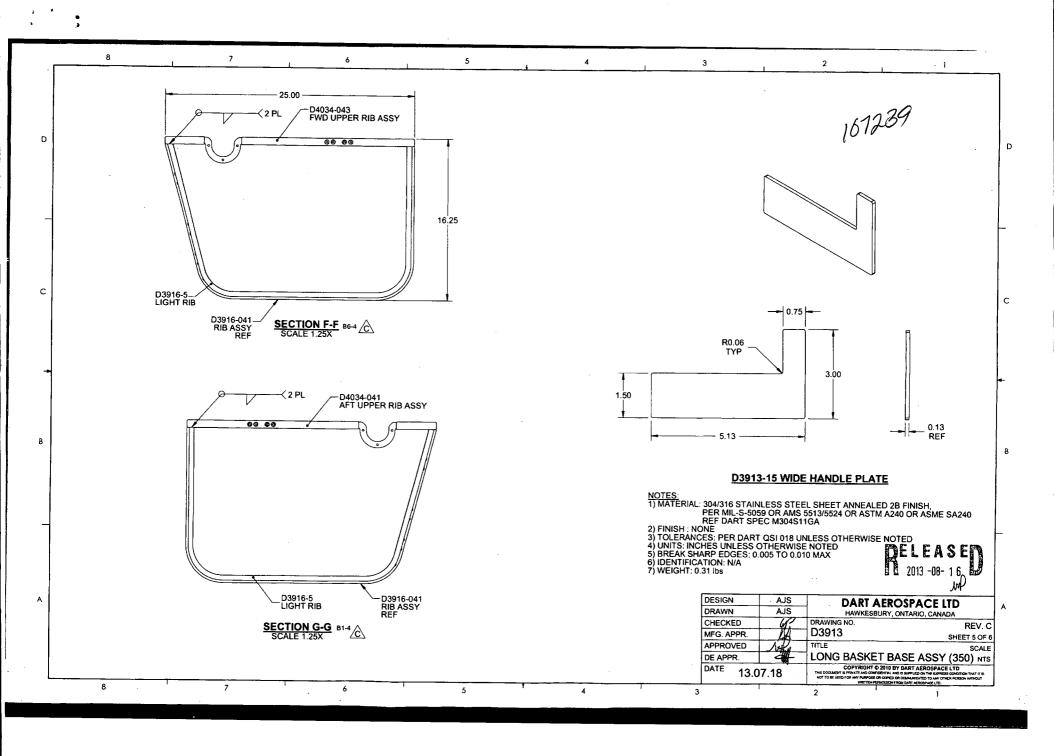
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

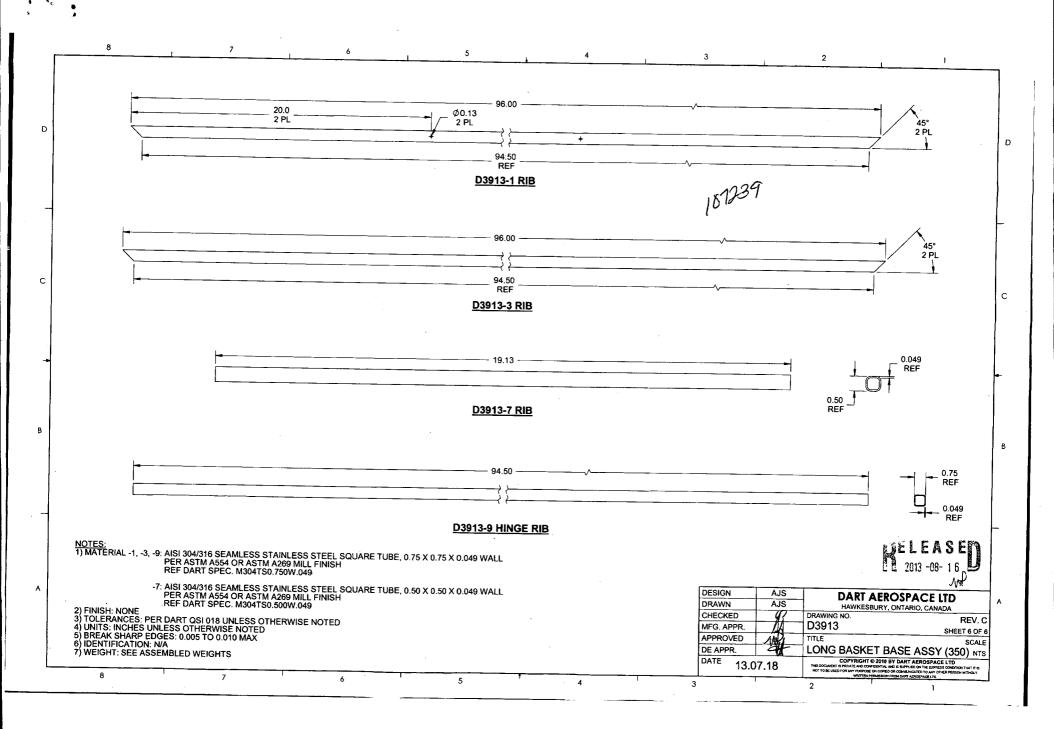


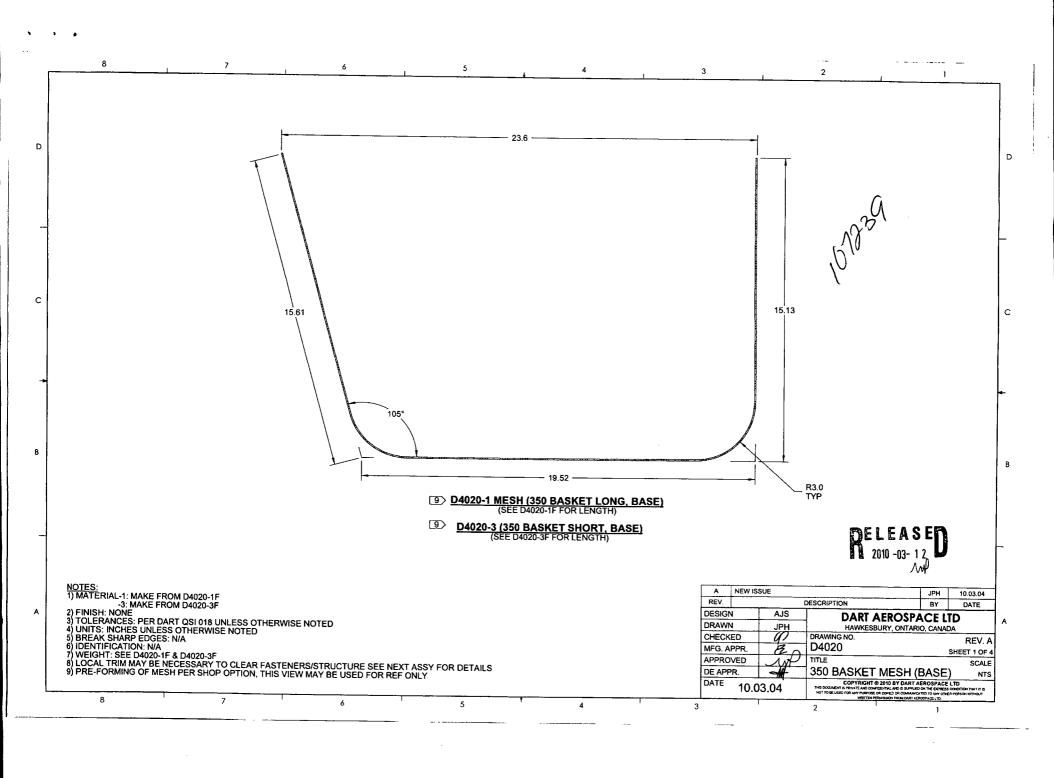












D4020-5: 95.25 D D4020-7: 56.00 D С С 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 D4020-5 MESH (350 BASKET LONG, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY) 9 D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT -5: 0.80 lbs APPROX DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED 9 DRAWING NO. REV. A D4020 MFG. APPR. SHEET 2 OF 4 ## 1-9. U.OU IDS AFFICIA
-7: 4.49 IBS APPROX

B) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

TOLERANCE ON XX.XX DIMENSIONS ± 0.06. APPROVED TITLE SCALE 350 BASKET MESH (BASE)

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PREDOCAMENT 6 PRIVATE NECESTRATION AND 6 SAPESS ON THE OWNERS CONTRION THAT IT OF USES FOR ANY PRIPAGE OF COMMANDATION OF OWNERS OF COMMANDATION OF OWNERS OF COMMANDATION OF OWNERS OF COMMANDATION OF COMMENTS OF COMMANDATION OF COMMENTS OF COMMANDATION OF COMMENTS O DE APPR. NTS DATE 10.03.04 8 6

0.40 8 R1.44 REF 15.50 2.00 0.38 5.64 R3.38 8 2 PL 20.18 REF 9 D4020-11 END MESH, BASKET

DESIGN AJS		DART AEROSPACE LTD							
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA							
CHECKED	a	DRAWING NO. RE	V. A						
MFG. APPR.	B	D4020 SHEET 3							
APPROVED	WA	TITLE	ALE						
DE APPR.	#	350 BASKET MESH (BASE)	NTS						
DATE 10.0	03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVITE MAY DEPOSE OR COPED OR COMMENTED THE EXPRESS CONSTRICT THE NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMENTED TO ANY OTHER PERSON WITHIN	IT IS						

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

8

8

6

5

8 D4020-1F 95.25 D4020-3F 56.00 5.13 5.13 2.25 D 2.25 D 48.25 2.25 2.25 5.13 5.13 (LOCAL SECTION MESH SHOWN FOR CLARITY) 8) D4020-3F MESH (350 BASKET SHORT, BASE) (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
8) TOLERANCE ON XX XX DIMENSIONS ± 0.06. DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN JPH CHECKED DRAWING NO. REV. A D4020 MFG. APPR. E SHEET 4 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE)

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